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71 Applicant: **T&N TECHNOLOGY LIMITED**  
**Cawston House Cawston**  
**Rugby Warwickshire, CV22 7SB(GB)**

Applicant: **WELLWORTHY LIMITED**  
**Southampton Road**  
**Lymington Hampshire, SO41 8XA(GB)**

72 Inventor: **Cole, Andrew Timothy**  
**38 Lawford Lane Bilton**  
**Rugby CV22 7JP(GB)**  
Inventor: **Munro, Robert**  
**Sutherland Lane 9 Avenue Road**  
**Lymington Hampshire SO41 9GP(GB)**

74 Representative: **Hadfield, Robert Franklin et al**  
**Bowdon House PO Box 20 Ashburton Road**  
**West Trafford Park**  
**Manchester M17 1RA(GB)**

54 **Pistons.**

57 A method is described of bonding a component in a piston, the method comprising the steps of coating the component surfaces to be bonded with an oxidation-resistant particulate material, preheating the coated component, placing the preheated component in a casting die and then casting an aluminium alloy around the component. The casting technique may comprise squeeze-casting.

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## Pistons

The present invention relates to pistons comprising aluminium-based alloys for internal combustion engines and particularly to such pistons having components of different metals therein.

Components such as ferrous inserts employed to enhance the wear characteristics of piston ring grooves, for example, are often incorporated by use of the well-known Alfin (trade mark) process.

- 6 The Alfin process is used in the manufacture of pistons by gravity casting and also by pressure casting methods such as squeeze casting, for example. Several problems can occur with the Alfin process and which can produce unsatisfactory bonds between the insert and the piston alloy. Such problems may include dirty or oxidised insert material, incorrect process conditions giving irregular intermetallic layer thickness and oxide dragged from the melt and entrained in the insert intermetallic surface coating.
- 10 Furthermore, the Alfin process is not amenable to automation, operator skill being essential in the successful operation of the process.

Even where the bond is not degraded by any of the above defects it is still relatively weak and brittle and may fracture during heat treatment or machining of the piston.

- 15 Pistons produced by pressure casting techniques are often intended for the highest rated engines and the aluminium alloy of which they are made is frequently heat treated to optimise the material properties. Heat treatments commonly used include a solution treatment and quenching operation often followed by a precipitation treatment. The solution treatment causes the thickness of the brittle iron-aluminium intermetallic layer to increase by diffusion and become even weaker whilst the thermal shock of the quenching operation either weakens the bond still further or may destroy it altogether. If the bond does not fail during
- 20 quenching it can fail due to the stresses generated during subsequent heat treatment or machining.

Kohnert et al in US 4334507 describe a porous insert formed of a porous material and which is impregnated with piston alloy by a pressure casting technique. A problem with this approach is that particles of the material from which the insert is produced may be loosened during machining and become dislodged in service leading to increased wear and damage.

- 25 A method has now been discovered of bonding a component in a piston and which overcomes the above disadvantages.

According to the present invention a method of bonding a component in a piston comprises the steps of coating the component surfaces to be bonded with a particulate material, preheating the coated component, placing the preheated component in a casting die and then casting an aluminium alloy around the

30 component.

The component should be in a clean, non-oxidised condition to allow coating with the particulate material. The particulate material may be deposited by a technique such as plasma, arc, flame spraying or other physical vapour deposition process, for example.

- 35 Preferably, the coating thickness may lie in the range 0.025 to 0.3mm and more preferably in the range from 0.05 to 0.15mm in thickness.

Preferably, the particulate material should be substantially oxidation-resistant at least up to the preheating temperature prior to casting of the aluminium alloy. Suitable materials may include austenitic stainless steels, nickel-based alloys, copper-based alloys and in some circumstances, ferritic stainless steel.

Preferably the casting method is a pressure casting technique such as squeeze casting, for example.

- 40 The component may be first coated with a tin layer by dipping or electro plating, for example, to enhance the bonding of the subsequent coating during a subsequent heat treatment prior to casting.

The coated component may also undergo a preliminary heat treatment to enhance the bond between the coating and the component prior to casting.

- 45 For some components such as ferrous crowns the particulate material may also comprise ceramic material which also affords some thermal barrier properties.

Other components which may be incorporated into a piston by this method include bushes in the gudgeon pin bosses and combustion chamber bowls in the crown.

- Components bonded to or into pistons in this manner do not need first to be dipped in molten aluminium as with the Alfin process. Therefore, no initial brittle layer of aluminium-iron intermetallic compound is formed.
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It is considered that the method of the present invention will permit heat treatments which allow the optimum properties of the aluminium alloy to be developed and which is not possible with current methods.

In order that the present invention may be more fully understood examples will now be described by way of illustration only.

A piston ring carrier insert of Ni-Resist (trade mark) iron was cleaned by abrasive grit blasting and

coated by plasma spraying with 0.12mm thick layer of 316L stainless steel powder. The coated ring carrier was then preheated to 400°C prior to placing in the female portion of a squeeze casting die. Lo-ex (trade mark) aluminium piston alloy at 740 to 760°C was then squeeze cast around the insert. The squeeze-casting pressure of 7 to 10 tsi was maintained until complete solidification had taken place.

5 Samples were taken from the cast piston which gave tensile strengths for the bond having a mean of 126.5 MPa. This gave an 80% strength increase over a typical Alfin bond as formed without any further heat treatment.

Other samples were prepared by the same method but having different sprayed layer thicknesses. The strengths of the interfaces were tested and gave the results shown in the Table below.

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Sprayed Layer Thickness (mm)	UTS (MPa)
0.025	126.8
0.025	119.0
0.05	124.3
0.05	148.5
0.10	120.9
0.10	152.5
0.20	130.8
0.20	117.8
0.30	102.9
0.30	130.2

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### Claims

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1. A method of bonding a component in a piston the method being characterised by comprising the steps of coating the component surfaces to be bonded with a layer of a particulate material, preheating the coated component, placing the preheated component in a casting die and then casting an aluminium alloy around the component.

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2. A method according to claim 1 characterised in that the coating step comprises plasma, arc or flame spraying.

3. A method according to either claim 1 or claim 2 characterised in that the particulate material is oxidation-resistant at least up to a desired preheating temperature.

4. A method according to any one preceding claim characterised in that the particulate material is chosen from the group comprising steels, stainless steels, nickel-based alloys and copper-based alloys.

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5. A method according to any one preceding claim characterised in that the alloy is cast by a squeeze-casting technique.

6. A method according to any one preceding claim characterised in that the component is one or more selected from the group comprising piston ring carrier; gudgeon pin boss bushes, combustion chamber bowl and piston crown.

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7. A method according to claim 4 characterised in that the material is 316L stainless steel powder.

8. A method according to any one preceding claim characterised in that the layer is between 0.025 and 0.3mm thick.

9. A method according to claim 8 characterised in that the layer is between 0.05 and 0.15mm thick.

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10. A method according to any one preceding claim characterised in that the coated component is heat treated prior to the preheating step.

11. A method according to any one preceding claim characterised in that the piston is heat treated subsequently to after casting.

12. A piston characterised by being made by the method of any one of claims 1 to 11.

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⑦① Applicant: **T&N TECHNOLOGY LIMITED**  
**Cawston House Cawston**  
**Rugby Warwickshire, CV22 7SB(GB)**

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DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.4)
Y	EP-A-0 109 814 (AE PLC) * Page 4, line 6 - page 7, line 16; figure 1 *	1,6	F 02 F 3/10 F 02 F 3/00 B 22 D 19/00
A	---	2	
Y	FR-A-2 284 769 (BRICO ENGINEERING) * Page 4, line 5 - page 6, line 9; figure 1 *	1,6	
A	---	4	
A	GB-A-2 156 478 (DANA CORP.) * Page 1, line 80 - page 3, line 47 * -----	1,5,6	
			TECHNICAL FIELDS SEARCHED (Int. Cl.4)
			F 02 F B 22 D
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 02-02-1990	Examiner MOUTON J.M.M.P.
<b>CATEGORY OF CITED DOCUMENTS</b>			
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document			
T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons ----- & : member of the same patent family, corresponding document			